



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18560

Job Sheet 170252



corb6

Part No: RBT18560

Job Qty: 6 ea

Part Name: Engine Gearbox Seal Puller



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18560 Rev 4 IPP Rev A 17.11.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/30/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	6 pcs		1/31/18	0.00	6.00	Small Fab		MDR
120	QC	6 pcs		1/31/18	0.00	0.00	QC5		38
130	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging3		9-80
140	QC21-FG	6 Ea		1/31/18	0.00	0.00	QC21		GA 145

Part Op 110 - Assemble as per DWG. Sheet 1
Descriptions:

DAS

21

9-80

APR 05 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	3408A940	2x 24	6	0	0
	90565A330 65	1x 12	25	0	0
	91255A542 69	2x 24	50	0	0
	94846A525 58	1x 12	50	0	0
	NTA-815 34	12	0	0	0
	RBT18560-1 145	6	0	0	0
	RBT18560-11	12	0	0	0
	RBT18560-3	6	0	0	0
	RBT18560-5	6	0	0	0
	RBT18560-9	6	0	0	0
	TRA-815 36	24	0	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S057990



Part: RBT18560

Job No: 170252

Serial No/Batch: S057990

Revision: 4

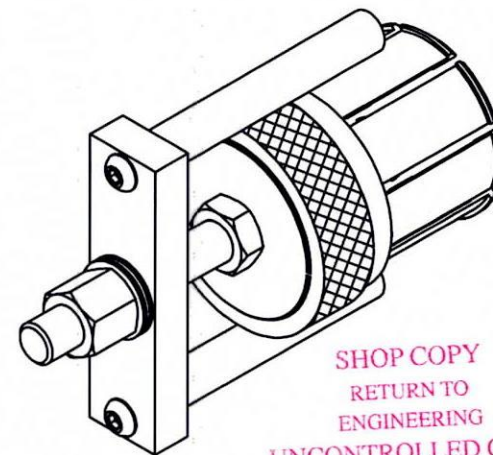
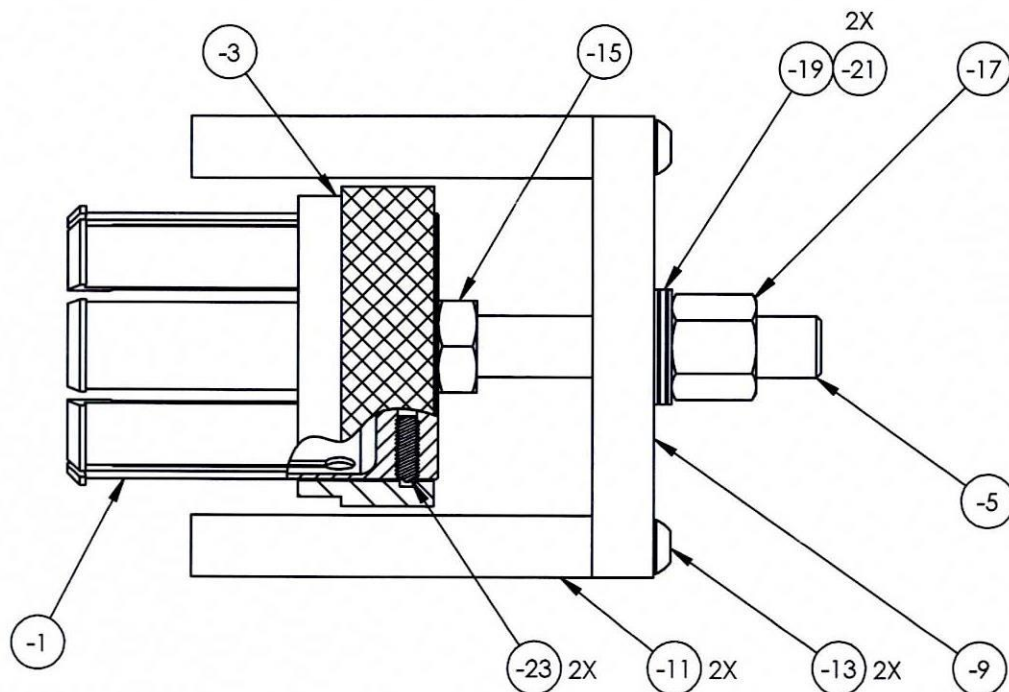
Inspector:

Date: 04/04/18

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

TEO ATTACHED

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 PULLER SLOT HOLES INCREASED TO Ø1/4 & WALL THINNED FOR FLEXABILITY, -3 RING SHORTENED & GROVE MOVED TO ALLOW -1 PULLER TEETH TO FULLY EXPAND, -7 ILLUMINATED, -9 CROSS BAR WIDTH INCREASED TO 1 FOR ADDED STRENGTH.	2/12/2003		
2		ADDED NEW BOM, TITLE BLOCK, & REV. TABLE. RE-ORGANIZED DWG.'S AND CORRECTED ERRORS. CREATED AN ASSEMBLY DWG, AND COMBINED TWO FILES.	11/20/2007	WP	RW
3		CH'D -9 HOLE FROM Ø.250 (X2) TO Ø.257 (X2) SER S.E.	12/29/2011	RJC	SE
4	15-0472	-9 CH'D ENGRAVE NOTE TO T/N, S/N, "MADE IN USA". UPDATED TO NEW DRAFTING STANDARDS.	1/5/2016	SM	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 170252
M/S
180112

NOTE:

1. USED ON BELL MODELS 206A, B, L1-L4.
SEAL #406-340-104-101

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PULLER	H13		2
			-3	1	RING	DOM		3
		B/O	-5	1	SCREW	STEEL	1/2-20 UNF X 4 IN THREADED ROD (MCMaster-CARR # 98750A483) MODIFIED	4
			-9	1	CROSS BAR	1018/1020 CR		5
			-11	2	UPRIGHT	1018/1020 CR		6
		B/O	-13	2	BTN-HEAD SKT CAP SCR	STEEL	1/4-20 UNC X 1 (MCMaster-CARR # 91255A542)	1
		B/O	-15	1	JAM NUT	STEEL	1/2-20 JAM NUT (MCMaster-CARR # 94846A525)	1
		B/O	-17	1	TALL NUT	STEEL	1/2-20 UNF (MCMaster-CARR # 90565A330)	1
		B/O	-19	1	THRUST BEARING	STEEL	APPLIED # NTA-815	1
		B/O	-21	2	BEARING WASHER	STEEL	APPLIED # TRA-815	1
		B/O	-23	2	BALL PLUNGER	S.S.	10-32 X 33/64 (MCMaster-CARR # 3408A94)	1

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560	REV 4
MAT'L _____ REAT _____ TREAT _____ FINISH _____ SPEC _____	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: COLE CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
SCALE 2:3	DATE 5/2/2002
SHEET 1 OF 6	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					